Work Order ID 70035 Wednesday, May 25, 2011 1:02:53 PM											Page 1
Revision ID:	D3372-5	_		Accept				s s	Setup Star		
	Cam Lock Sha 5/25/2011 6/10/2011	Start Qty: 4.00 Req'd Qty: 4.00			Cust Item I Customer:	D:		-	Sto	P	
Approvals:	Process Pla	ın: CL	Date: 11/05/25	Tooling: SPC (Y/N):		ate:		F	Run Star Sto		
Sequence ID/ Work Center ID)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr		ision Nbr		V							
D3372 100 Doosan Doosan Lathe	Rev	Hardinge CNC LATH	D3372-5 as per Folio FA497 a	0.00 0.00 nd Dwg D3372	760 U	/os/3	0	4	φ		
110 QC Quality Control		Deburr QC2- Inspect parts of	f machine FAI/FAIB	0.00	A 11/0°	5/30		_4_	_ \$\phi		
120 		QC8- Inspect parts - s	econd check	0.00	L 11/05/30			4_	ø		

0.00

Memo

Quality Control

Dart Aerospace Ltd

W/O:			W	ORK ORDER CH	ER CHANGES					
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					<u> </u>					
		·								
				•						
Part No	<u> </u>	PAR #:	Fault Ca	tegory:	-	NCR: Yes	No DQ	A:	Date: _	
		esolution:							· ·	
NCR:		\	WORK OR	DER NON-CONFO	RMAN	ICE (NCR	()		10.0	
DATE STEP		Description of NC		Corrective Action	Section B		Verifi	cation	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Descrip Chief Eng	tion	Sign & Date	Sec	Section C	Chief Eng	QC Inspector
			į .							
					}					
	}									

NOTE: Date & initial all entries

Work Order ID 70035

Wednesday, May 25, 2011 1:02:53 PM



Page 2

Item ID:

D3372-5

Accept

Setup Start



Revision ID:

Start Date:

Cam Lock Shaft Item Name:

Required Date: 6/10/2011

5/25/2011

Start Qty: 4.00

Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

Date:

Start

Stop



QC:

Date:_____

SPC (Y/N):

Set Up/

Date:

Stop

Reject

Qty



Sequence ID/ **Work Center ID**

130



Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

0.00

Run Hours

Tool ID

Tool # Plan Code

Accept Qty

Run

Reject Number

Insp. Stamp

140



Packaging

Identify as per dwg & Stock Location:

Memo

Memo



0.00

0.00

150



Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								·		
		·								
Part No: PAR #: Fault Category: Disposition:				egory:	NCR: Yes No DQA: Date:					
	R								Date:	
NCR:		\	WORK ORL	DER NON-CONFO	PRMANC	E (NCH	()			e e e e e e e e e e e e e e e e e e e
D.175 0750		Description of NC		Section B V			cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Descrip	tion	Sign & Date	Sec	tion C	Chief Eng	QC Inspector
v	r									

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 1:02:51 PM

Work Order ID: 70035

D3372-5

Parent Item Name: Cam Lock Shaft



Start Date: 5/25/2011

Required Date: 6/10/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

Parent Item:

IPP A□05.01.18□New issue□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.375		Purchased	No			100	f	31.2310	0.075	0.315789			

303 Round Bar 0.375"

Location	Loc Qty	Loc Code
MAT028	31.231	
115806	7.141	
115868	24.09	

Dart	Aeros	pace	Ltd

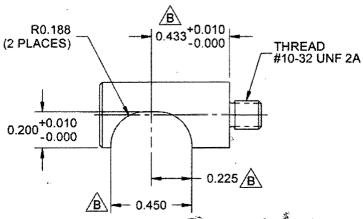
W/O:		WORK ORDER CHANGES											
DATE	STEP	PROC	EDURE C	HANGE	1000	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No:		PAR #:	_ Fault Ca	ategory:	NCR: Yes No DQA:				Date:				
	R	esolution:	_ Disposit	tion:	Q	A: N/C C	losed:		Date: _	<u>* 1</u>			
NCR:		W	ORK OR	DER NON-CONF	PRMANC	E (NCF	R)			` 4			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Action Descr		Sign &			Approval Chief Eng	Approval and QC Inspector			
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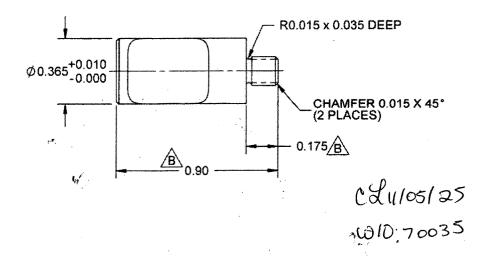
NOTE: Date & initial all entries



1	1		
DESIGN	DRAWNBY	DART AEROS HAWKESBURY, ON	
CHECKED	ARPROVED	DRAWING NO. D3372	REV. B SHEET 6 OF 8
DATE 05	.02.23	TITLE COLLECTIVE LOCI	SCALE 2:1







D3372-5 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC, M303R0.375) 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD	Work Order:	70035
Description: CAM Lock STUCK	Part Number:)3372-5
Inspection Dwg: 3372 Rev: 8		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Rejest	Method of Inspection	Comments
,365	4.010	,366			RAZL	Vern
. 90	±.030	,904			М	
.175	1.010	. 180		1	и	
,450	1.010	,451			И	
, 433	+,0/0	-135			11	
RD.188	R-1875 1.010	R.1875			~(
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Measured by:	97	Audited by:	Prototype Approval:	
	<i></i>		D. (-	
Date:	11/05/30	Date: ///5 /20	Date:	

		<u> </u>	Revised by	Approved
Rev	Date	Change	KJ/JLM	1
А		New Issue	NOTOLIVI	<u> </u>

